



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

report

647.7702

Job Sheet 201890



Part No: 647.7702

Job Qty: 8 pcs

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/19

Job Tracking No:

Due Date: 11/18/19

NOV 25 LATEST

Created By: Marie Lajeunesse

Type: Stock

5000

Description:

Note: DWG REV A2 IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
120	Large Fab - Welded Assy-1	8 pcs	11/18/19		0.00	3.29	Large Fab - 1	mw
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
							Large Fab - 11 (Various)	
							Large Fab - 12	
130	QC 9	8 pcs	11/18/19		0.00	0.00	QC 9 - 10	ea
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	
							QC 9 - 50	
							QC 9 - 9	
140	QC 5	8 pcs	11/18/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	



Container No: S229624

rB47.7702
b No: 201890
rial No/Batch: S229624
rision:
ector:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A
CANADA
TEL.: 1 813 832-85
Email: sales@dartae
www.dartaerospace.

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Container No: S229624



Part No: 647.7702

Job No: 201890

Serial No/Batch: S229624

Revision:

Operator:

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CANADA
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					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150	Outsource - 3 - Cadplate	8 pcs	11/18/19		GRO002-VC	7 1209-11-12
160	Packaging 2-1 - Receive - B4B	8 pcs	11/18/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	DP NOV 21 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
170	QC 6	8 pcs	11/18/19	0.00 0.00	QC 6 - 9	DAS
					QC 6 - 68	NOV 21 2019 68
					QC 6 - 61	9-89
					QC 6 - 40	
					QC 6 - 81	DAS
180	Spray Paint - 2 - B4B	8 pcs	11/18/19	0.00 0.62	Spray Paint - 1 - B4B	41 NOV 22 2019
					Spray Paint - 2 - B4B	3-89
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
190	QC 14	8 pcs	11/18/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	

Hand
Ship
NOV
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DAS
40
9-89

					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	NOV 2 5 2019
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
200	Packaging 3-1 - Stock - B4B	8 pcs	11/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	DAS 28 9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210	QC 21 - SA	8 pcs	11/18/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89
					QC 21 - SA - 70	NOV 2 5 2019
					QC 21 - SA - 53	

Part Op 120 - (Weld per dwg A/R 4130 rod Batch: M12725) 1- ASSEMBLE AND WELD AS PER DWG 0 ***IMPORTANT
 Descriptions: DIMENSION IS 11.60" ***
 130 - (QC9- Inspect visual per QSI004- Fusion Welds)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - Outsource3 (Outsource process-Cadplate per QSI017 4.1.9.1) Issue P/O : 45076 Group Altech CAD
 PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread
 160 - (Receive & Inspect for Damage & Mat'l Certs)
 170 - INSPECT USING GO/NO GO GAUGE
 180 - (Spray Paint / NDT Room) PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG PRIMER
 BATCH: 5195271
 190 - (QC14- Inspect Spray Paint)
 200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release) PLEASE NOTE ON PO: Apply only Class 3 Cad to the threaded are only CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.7711	Strut Tube	8 pcs (1 ea)	120-Large Fab - Welded Assy-1	5107258
647.7712	Strut Tube	8 pcs (1 ea)	120-Large Fab - Welded Assy-1	5107260 / 5222553 18
647.7713	Strut Thread	8 pcs (1 ea)	120-Large Fab - Welded Assy-1	5222914

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Large Fab - Welded Assy-1	647.7711	8	24	0
	647.7712	8	45	0
	647.7713	8	38	0

Part Specifications

Specifications could not be found.

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER POHB045076



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3668

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045076

PO Date: 11/12/19

Due Date: 11/20/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

EMAILED
2019-11-14

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201890	647.7702	647.7700 Rev A2	Strut Assembly : Various STC's Outsource3 (Outsource process-Cadplate per QSI017 4.1.9.1) Issue P/O _____ Group Altech CAD PLATE IAW QQ-P- 416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	-	11/20/19	8 pcs	0 pcs	8 pcs	\$15.89/pcs	\$127.12
2	201000	647.7703	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O _____ Group Altech CAD PLATE IAW QQ-P- 416F CLASS I TYPE II ****NOTE: limit cad plating on thread to 0.003" or less****	Firmed	-	11/20/19	10 pcs	0 pcs	10 pcs	\$12.35/pcs	\$123.50
	200600				Firmed	-	11/20/19	10 pcs	0 pcs	10 pcs	\$12.35/pcs	\$123.50
Sub Total:								20	0	20		\$247.00
Grand Total:												\$374.12

Grenon



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PURCHASE ORDER POHB045076



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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Certificat de Conformité / Certificate of Compliance

(024054-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

024054 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
20-Nov-2019		Jigar Patel				POHB045076				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
1	647-7702 Rev.A2	647-7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2 0.0005" (CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD)		CADMIUM CH	8	8	0	0	0	
2	647-7703 Rev.A2	647-7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2 0.0005 " (LIMIT CAD PLATING ON THREAD TO 0.0003 " OR LESS)		CADMIUM CH	10	10	0	0	0	
3	647-7703 Rev.A2	647-7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2 0.0005 " (LIMIT CAD PLATING ON THREAD TO 0.0003 " OR LESS)		CADMIUM CH	10	10	0	0	0	

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NOV 21 2019
DART AEROSPACE LTD.

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.